

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015092**Date Inspected:** 09-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou cheng / Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld joint 2G-006 located on PCMK BK004A-008 the welder is identified as 062757. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4c-F.

FCAW welding of weld joint 1G-008 located on PCMK BK004A-008 the welder is identified as 062761. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 3G-030 located on PCMK BK004A-008 the welder is identified as 062788. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of repair weld joint 2G-019 located on PCMK SB013-062 of SB62W the welder is identified as 062755. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G (2F)-Repair-1 and B-WR13468.

FCAW welding of repair weld joint 2G-004 located on PCMK SB016-070 of SB70W the welder is identified as

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062755. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G (2F)-Repair-1 and B-WR13352.

ZPMC QC NDT technician doing their MT of base metal repaired location of following bike path is in progress, the bike path is identified as BK006A-001.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Suspender bracket. The weld designations reviewed as follows. NWIT-005939.

SB014-052-001,005,009,015,037,049,061,055,077.

SB014-054-004 , this CJP weld needs flush grind to smooth but this QA inspector found that 5mm out of flatness found, so ZPMC cancelled this item from this notification.

## OUTSIDE SHOP

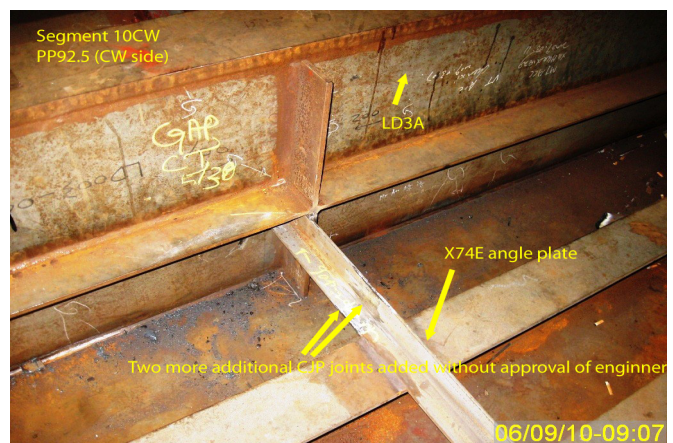
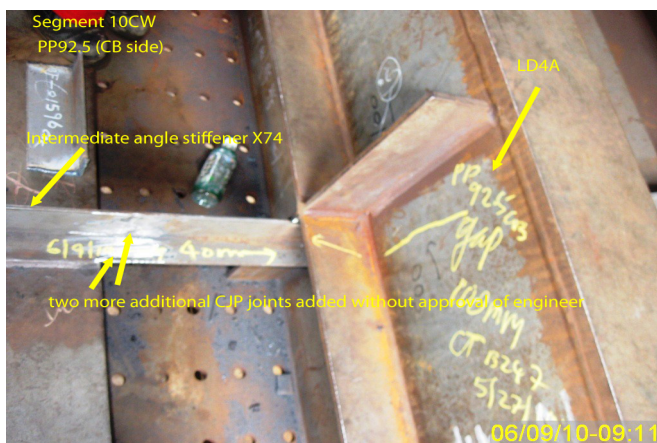
### 11EW

SMAW welding of weld joint 4G-010 located on PCMK SEG073A of Segment 11EW welder is identified as 051378. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-Repair-1 and B-WR13529.

### 10CW

Two additional weld added without engineer approval in segment 10CW , the location is identified as intermediate panel point angle(X74E) which is connecting the LD in both CB side and CW side @ PP92.5. This additional joint added because of the gap between angle to Longitudinal diaphragm observed 100mm in CB side and 95mm in CW side. This informed to ZPMC QC Mr.Wang wei ming and also informed to CT SMR Mr.Eric tsang. ZPMC QC said we will make report for this rectification work. For more information please see the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

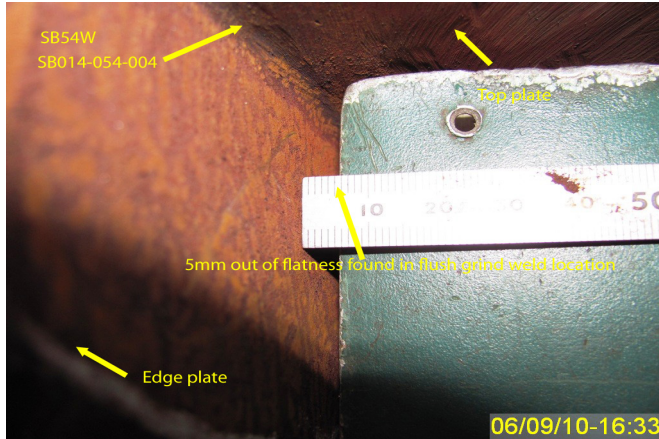


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## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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